

Work Order ID 134491

134491

Page 1

Wednesday, July 08, 2015 3:16:55 PM

Item ID: D119-796-251 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: AFT Crosstube Installation with Step (no hardware) Stop *NS2*

Start Date: 7/07/15 Start Qty: 1.00 *1*

Required Date: 7/07/15 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS Date: JUL 10 2015 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-251	D								
110	Document Control	0.00							DAS 41 9-89
110									
DC	Memo	0.00							
Doc.Control -USB or Paperwork		Photocopy bluefile and create labels as per PPP D119-796-251 chg 002							
120	Pick Kit	0.00							DAS 41 9-89
120	Packaging								
Packaging	Memo	0.00							15-9-3
Packaging									
130	Crosstubes	0.00							DAS 41 9-89
130									
Crosstubes	Memo	0.00							
Crosstubes		1- Install step and clamp with the proper position per dwg D119-796-251							

Torque all clamps to 50 IN-LBS max.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Work Order ID 134491

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Item ID: D119-796-251 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AFT Crosstube Installation with Step (no hardware)
 Start Date: 7/07/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/07/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89
140									
QC	Memo	0.00							
Quality Control	***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***								SEP 09 2015
150	Packaging	0.00				1			PPS 9-25
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-251								PP 134491 135021
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							MLC SEP 28 2015
Quality Control									

PPS 9-25

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	☐ OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

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Work Order ID: 134491

134491

Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B
14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19
AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER
REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D
JLM VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-241		Manufactured	No				Each	0.0000		1			
D119-796-241					131317				**	1		DAS 41 9-89	15-9-3
AFT Crosstube Installation without Step (no hardware)													
D5123-3		Manufactured	No				Each	52.0000		4			
D5123-3									**			DAS 41 9-89	15-9-3
Clamp Cushion										4			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				LG055	13								
					133460								
				lg55	39								
					126747								
					127133								
					131871								
D5149-043		Manufactured	No				Each	2.0000		2			
D5149-043									**			DAS 41 9-89	15-9-3
Aft Step Base Assembly										1			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				LG054	1								
					131333								
				LG058	1								
					129892								

DQA: _____ Date: _____



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Work Order ID: 134491

134491

Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 1.00

Required Qty: 1.00

MS21920-25

Purchased

No

Each

176.0000

4

DAS

MS21920-25

41

9-89

15-9-3

Clamp

Location

Loc Qty

Loc Code

FG

10

120920

10

LG050

26

M130400

10

M131367

3

M132169

11

M132522

2

LG057

140

M132674

40

M132675

100

4

DQA: _____ Date: _____



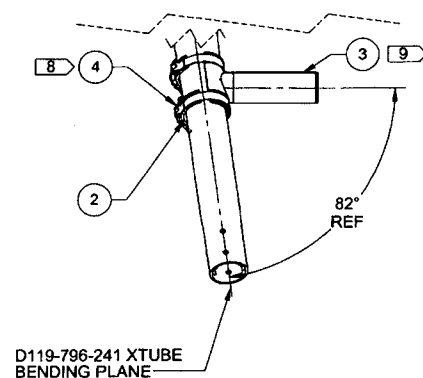
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OTHER :																					

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP



SECTION A-A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

D119-796-251 XTUBE ASSY (AW119 MKII AFT)

RELEASED

2015 FEB 09

ECN 15-516

D	D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED SECTION A-A	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A	AP	14.10.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO. REV. D	
MFG. APPR.	DD	D119-796-251 SHEET 1 OF 1	
APPROVED	HS	TITLE SCALE	
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT) NTS	
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED